

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020653**Date Inspected:** 15-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

West Grillage:

Repair welding of weld joint no: SA7512C-253, complete joint penetration (CJP) weld. The welder is identified as 066398 and was observed welding in the 1G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ABF QA was identified as Ji Cai Feng. The welding variables appeared to comply with Welding procedure specification (WPS): 345-SMAW-1G(1F)-FCM-Repair-1. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2629 Rev-3. See attached photo for details.

OBG Seg 13CW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3015A-014 [Side Panel (SP) 3097A to Corner Assembly (CA) 3016A, CJP weld]. The welder is identified as 067734 and was observed welding in the 1G

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position. ZPMC Quality Control (QC) was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2231T-ESAB-1. Welding was observed to be done with ceramic backing.

The SMAW process on weld joint no: CA3016A-101 and 098 [Edge Panel (EP) to Deck Panel (DP) and EP to SP, CJP weld at PP122.5]. The welder is identified as 037796 and was observed welding in the 1G and 4G positions for the respective welds. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: B-P-2211-Tc-U4b-FCM-1 and B-P-2214-Tc-U4b-FCM-1.

OBG Seg 13BW:

The SMAW process on weld joint no: CA3015A-003 and 006 (EP to DP & EP to SP, CJP weld at PP122.5). The welder is identified as 037796 and was observed welding in the 1G and 4G positions for the respective welds. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: B-P-2211-Tc-U4b-FCM-1 and B-P-2214-Tc-U4b-FCM-1.

OBG Seg 14W:

The FCAW process on weld joint no: SEG3020BB-115 [Anchorage Plate (AP) 3032A to Sub Assembly Vertical Shear Plate (VSP) SA3448A, CJP weld at PP126]. The welder is identified as 066421 and was observed welding in the 3G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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